



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-311
Job Sheet 171664-A



Part No: D350-591-311

Job Qty: 1 ea

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 2/16/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	HandFinish	1 pcs	2/15/18	2/15/18	0.00	0.18	HandFinish1		
150	QC	1 pcs	2/15/18	2/15/18	0.00	0.00	QC7-2		18-02-22
180	Large Fab	1 pcs	2/15/18	2/15/18	0.00	0.99	Large Fab 2		18-02-22
190	QC	1 pcs	2/15/18	2/15/18	0.00	0.00	QC10		18-02-22
200	QC	1 pcs	2/15/18	2/15/18	0.00	0.00	QC5		18-02-22
210	HandFinish	1 pcs	2/15/18	2/15/18	0.00	0.18	HandFinish1		18-02-22
220	Powdercoat	1 pcs	2/15/18	2/15/18	0.00	0.29	Powdercoat1		18-02-22
230	HandFinish	1 pcs	2/16/18	2/16/18	0.00	0.18	HandFinish3		18-02-22
240	QC	1 pcs	2/16/18	2/16/18	0.00	0.00	QC3		18-02-22
250	Packaging	1 pcs	2/16/18	2/16/18	0.00	0.00	Packaging1-3		FEB 26 2018
260	QC	1 pcs	2/16/18	2/16/18	0.00	0.00	QC4		SMB
265	DC	1 pcs	2/16/18	2/16/18	0.00	0.00	DC		SMB
270	Packaging	1 pcs	2/16/18	2/16/18	0.00	0.00	Packaging3-1		SMB
280	QC21-FG	1 Ea	2/16/18	2/16/18	0.00	0.00	QC21		FEB 27 2018

Part Op 180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for Descriptions: welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: 11:45 OVEN TEMPERATURE: 320° FINISH TIME: 12:15 M138467.
265 - Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
270 - Identify and pack for shipping as per PPPD350-591-311 Location : FG084

wing walk M138761

GO1134

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3065-041	Step Leg Assembly	1 Ea (1 ea)	180-Large Fab	
D3066-1	Spacer	2 Ea (2 ea)	180-Large Fab	
MS20600-AD4W4	Rivet	16 Ea (16 ea)	180-Large Fab	
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	
D2618	Bushing	2 Ea (2 ea)	250-Packaging	
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
180-Large Fab	D3065-041	1	12	0
	D3066-1	2	50	0
	MS20600-AD4W4	16	2,001	0
250-Packaging	AN3-35A	2	162	0
	AN4-13A	8	563	0
	AN5-36A	2	188	0
	D2230-3	4	129	0
	D2618	2	276	0
	D2856-400-720	2	129	0
	D3235-1	2	54	0
	D3278-041	1	20	0
	MS21042L3	2	3,495	0
	MS21042L4	8	1,222	0
	MS21042L5	2	961	0
	NAS1149D0363J	4	3,533	0
	NAS1149D0463J	16	2,743	0
	NAS1149D0563J	4	1,454	0
Part Specifications				
Specifications could not be found.				

Plex 2/22/18 7:45 AM dart.lacelle.linda

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaero.com



Container No: S044476

Part: D350-591-311

Job No: 171664-A

Serial No/Batch: S042351

Revision: D3272

Inspector: _____

Date: 02/22/16

AGAINST DEPARTMENT/PROCESS

Cross tube ☐

Tab ☐

Water Jet ☐

Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Supplier ☐

Engineering ☐

Quality ☐

Other ☐

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced

Bending

Centre Not Concentric

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Temperature, etc.

Set-up

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

EGORY

Power Loss/Surge

Folio/Program

Grain

Weld

Wrong Stock Pulled

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

OTHER :



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 001136

Tel (613) 632-5200

Containers on Master Unit 001136				
Serial No	Part No	Customer Part No	Status	Quantity
S044867	AN3-35A		Allocated	2
S044866	AN4-13A	AN4-13A	Allocated	8
S044864	AN5-36A	AN5-36A	Allocated	2
S044861	D2230-3	D2230-3	Allocated	4
S044860	D2618	D2618	Allocated	2
S044858	D2856-400-720	D2856-400-720	Allocated	2
S044855	D3235-1	D3235-1	Allocated	2
S044854	D3278-041	D3278-041	Allocated	1
S044853	MS21042L3	MS21042L3	Allocated	2
S044852	MS21042L4	MS21042L4	Allocated	8
S044851	MS21042L5	MS21042L5	Allocated	2
S044850	NAS1149D0363J	NAS1149D0363J	Allocated	4
S044848	NAS1149D0463J	NAS1149D0463J	Allocated	16
S044847	NAS1149D0563J	NAS1149D0563J	Allocated	4

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Hel-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Hel-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Hel-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Hel-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Hel-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Hel-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]